

# Work Order ID 126057

October-27-14 11:49:07 AM

\*126057\*

Page 1

Item ID: D3120-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Cover

Stop \*NS2\*

Start Date: 10/27/14 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 10/31/14 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3120	Rev B								

110

0.00

\*110\*

Waterjet

FLOW CNC Waterjet

2024 030

HAAS CNC VERTICAL MACHINING #1

Memo

Cut as per dwg D3120

Prog rev: B

Dwg rev: B

Deburr as required

4 4 0 14/10/28  
4 0 14-11-05

DAS  
23  
9-89

120

0.00

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

4 0 14/10/28  
4 0 14-11-05  
p/o →

DAS  
23  
9-89

DQA:

Date: 14/11/17



QA Closed:

Date: 14/12/16

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>126057</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D3120-2</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4493</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input checked="" type="checkbox"/>									
Doc/Data <input checked="" type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input checked="" type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**\*126057\***

Page 2

Item ID: D3120-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Cover  
Start Date: 10/27/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 10/31/14 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				(4)			DAS 38 9-89 NOV 0 6 2014
135 <b>*135*</b> Brake NC Brake NC	Memo 1-deburr if necessary 2-bend as per dwg	0.00  0.00			DAS 30 9-89	4			14/11/12
136 <b>*136*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(4)			DAS 38 9-89 NOV 12 2014

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Page 3

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 Start Date: 10/27/14 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 10/31/14 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00				4	0	14-11-12	Dec
*140*	HandFinish	0.00							
Hand Finishing	Memo								
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				4	0	14-11-14	
*150*	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 8:40								
	FINISH TIME: 9:10								
160	QC3- Inspect Part Finish	0.00							
*160*	QC	0.00							
Quality Control	Memo								

NOV 18 2014

DAS 34 9-89

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Page 4

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Required Date: 10/31/14 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>S1 488</u>	0.00				4	14/11/19		
<b>*170*</b>	Packaging	0.00							
	Memo								
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>	QC	0.00							
	Quality Control								

14/11/19 *[Signature]*

④ 14-11-19

# Picklist Print

October-27-14 11:49:06 AM

Work Order ID: 126057

\*126057\*

Parent Item: D3120-2

\*D3120-2\*

Parent Item Name: Cover

Start Date: 10/27/14

Required Date: 10/31/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A02.05.13New IssueNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

110

sf

262.1668

0.2179

1

\*M2024T3S 032\*

\*\*

12/14/10/28

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT022

262.1668

M130497

262.1668

1.59722

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	126057
<b>Description:</b> Cover		<b>Part Number:</b>	D3120-2
<b>Inspection Dwg:</b> D3120 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

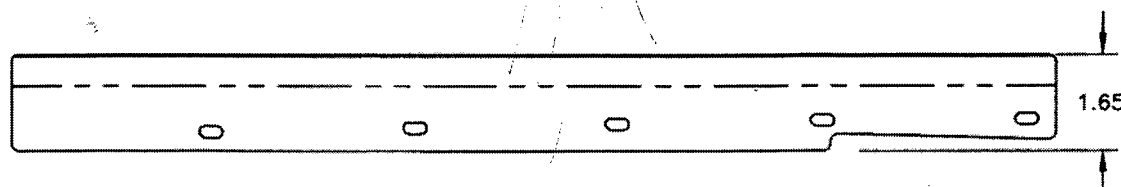
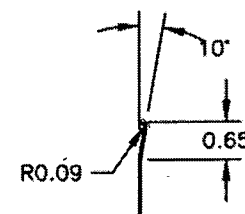
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201 x 0.400	+0.005/-0.001 x +/-0.010	.205 x .4001	✓		√	Jkmo1
0.323	+/-0.010	.323	✓		√	
0.388	+/-0.010	.388	✓		√	
0.453	+/-0.010	.453	✓		√	
0.517	+/-0.010	.517	✓		√	
0.544	+/-0.010	.544	✓		√	
1.33	+/-0.030	1.33	✓		√	
1.43	+/-0.030	1.424	✓		√	
1.68	+/-0.030	1.68	✓		√	
0.500	+/-0.010	.500	✓		√	
4.000	+/-0.010	4.000	✓		√	
7.500	+/-0.010	7.500	✓		√	
11.000	+/-0.010	11.000	✓		√	
14.500	+/-0.010	14.500	✓		T	Jkmo7
17.95	+/-0.030	17.95	✓		T	
0.032	+/-0.010	.032	✓		√	

<b>Measured by:</b> <i>De/12</i> <b>DAS 23</b> <b>Date:</b> 14/10/28		<b>Audited by:</b> <b>DAS 38</b> <b>Date:</b> NOV 06 2014		<b>Prototype Approval:</b> N/A <b>Date:</b> N/A	
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>	
A	09.09.14	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>	

14-11-05



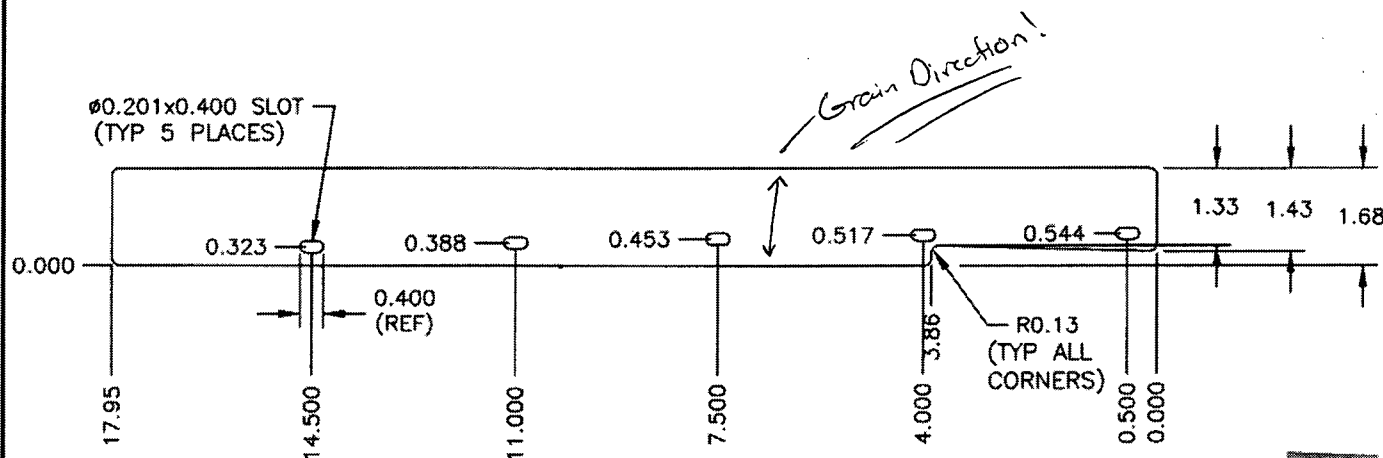
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA	REV. B
DATE	04.10.18	DRAWING NO.	D3120	SHEET 1 OF 2	
		TITLE	COVER	SCALE	NTS
A	02.04.15	NEW ISSUE			
B	04.10.18	ADD PART MARKING			



### BEND DETAIL

**D3120-1 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-229)**

**D3120-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-230)**



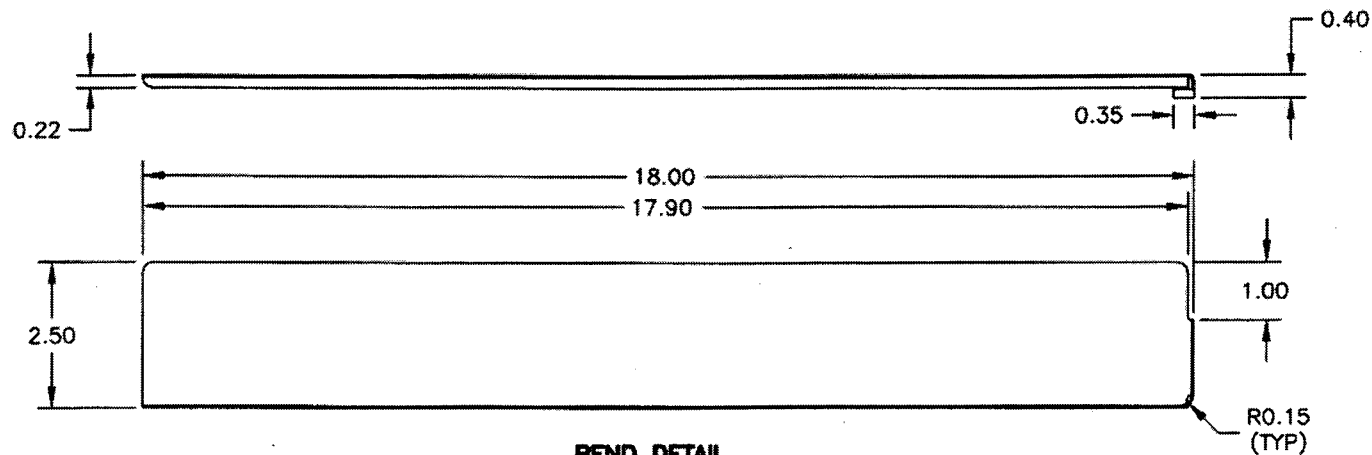
### D3120-1/-2 COVER. FLAT PATTERN

#### D3120-1/-2 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

RELEASED  
04-11-23

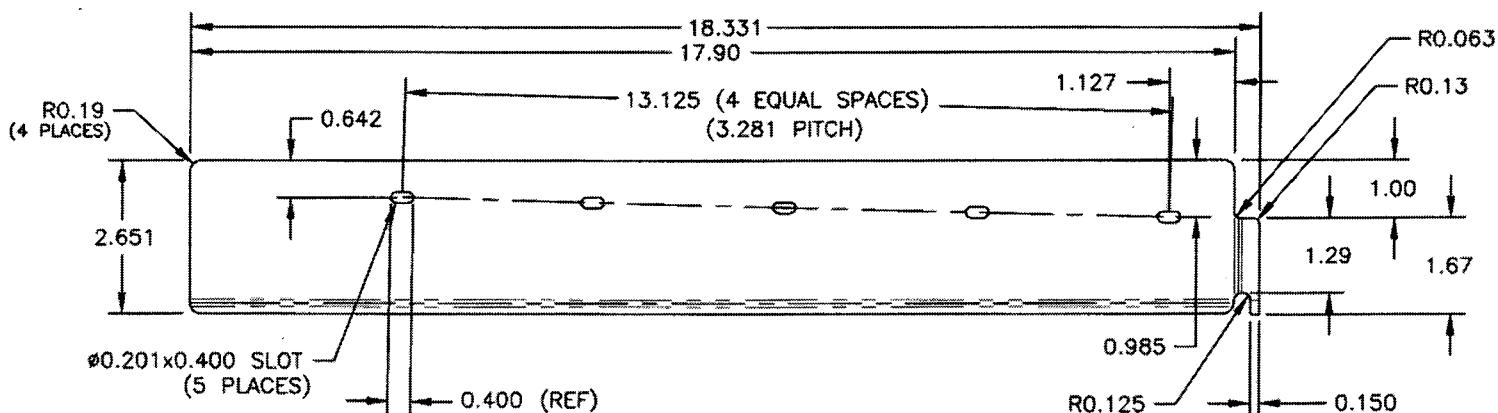




**BEND DETAIL**

**D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)**

**D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)**



**D3120-3/-4 COVER. FLAT PATTERN**

**D3120-3/-4 NOTES**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

RELEASED  
01/11/23



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D3120	SHEET 2 OF 2
DATE 04.10.18	TITLE COVER	SCALE NTS	